

Work Order ID 83907

83907

Page 1

April-27-12 11:17:19 AM

Item ID: D2221-1 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Rib
 Start Date: 27/04/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 11/05/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/27 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D2221 | Rev H |

| | | | | | | | | | |
|-----------|---|------|--|--|--|--|--|--|--|
| 100 | Large Fab | 0.00 | | | | | | | |
| *100* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | 1- Cut as per dwg D2221 2- Deburr and remove identification markings on tube | | | | | | | | |

10 SAD 12.05.22

| | | | | | | | | | |
|-----------------|------------------------------------|------|--|--|--|--|--|--|--|
| 110 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

10x 12.05.23

| | | | | | | | | | |
|-----------|---|------|--|--|--|--|--|--|--|
| 120 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

10x 12.05.23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

April-27-12 11:17:19 AM

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Rib

Start Date: 27/04/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 11/05/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/5/23

A handwritten signature in black ink, appearing to be "mf".

1205-23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

April-27-12 11:17:24 AM

Page 1

Work Order ID: 83907

83907

Parent Item: D2221-1

D2221-1

Parent Item Name: Rib

Start Date: 27/04/2012

Required Date: 11/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:A New Issue 08-12-02 DD verified by:EC
11.01.13 chg qc5 to 6 DD verified by:EC

IPP Rev:B

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M304TS0.750W.065 | | Purchased | | | No | 100 | f | 1,013.792 | 8 | 33.68421 | | | |

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

SAD

12.05.22

| Location | Loc Qty | Loc Code |
|----------|-------------|----------|
| MAT017 | 553.7325342 | |
| 120267 | 53.7325342 | |
| 120633 | 500 | |
| MAT018 | 453.40289 | |
| 121170 | 412.40289 | |
| 7636 | 41 | |
| WA007 | 0.5907428 | |
| 116763 | 0.5907428 | |
| WA035 | 6.0667 | |
| 118181 | 6.0667 | |

84.2105

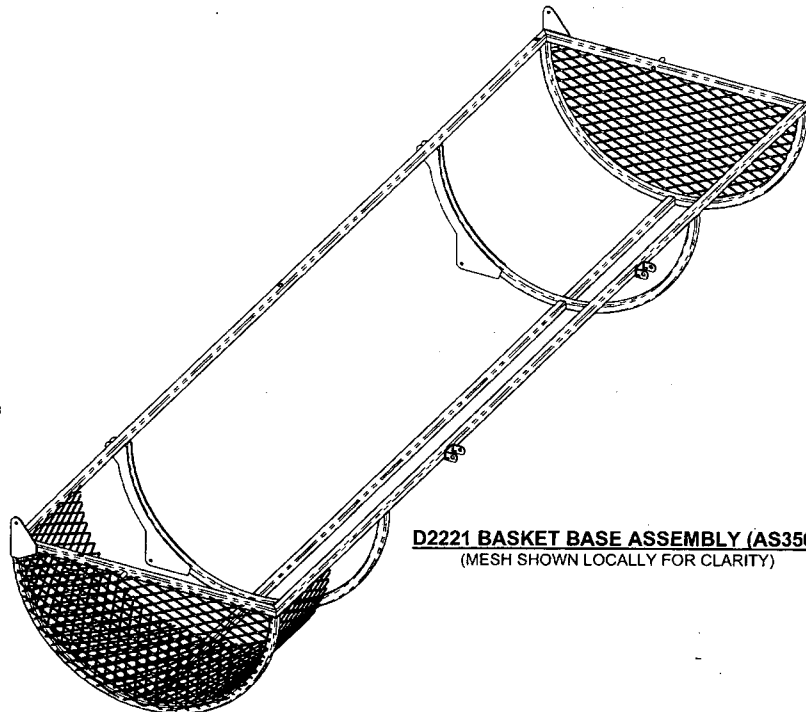
| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

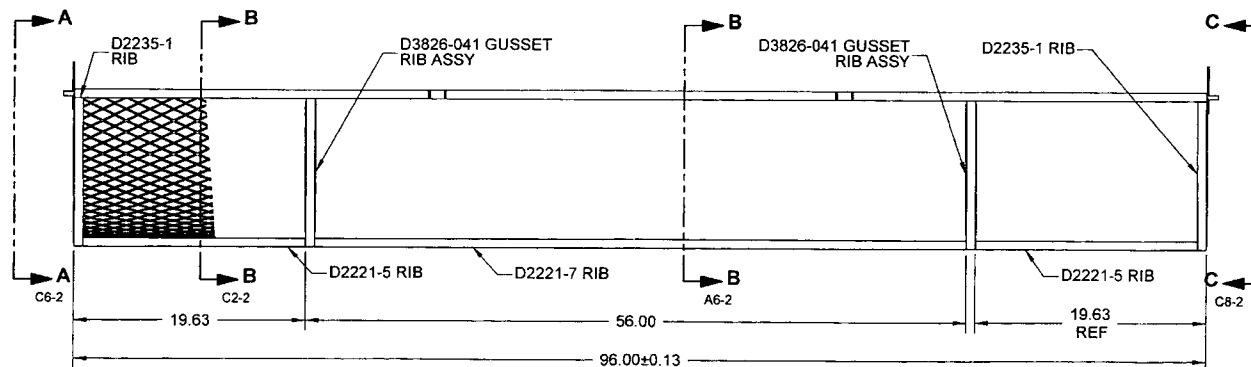
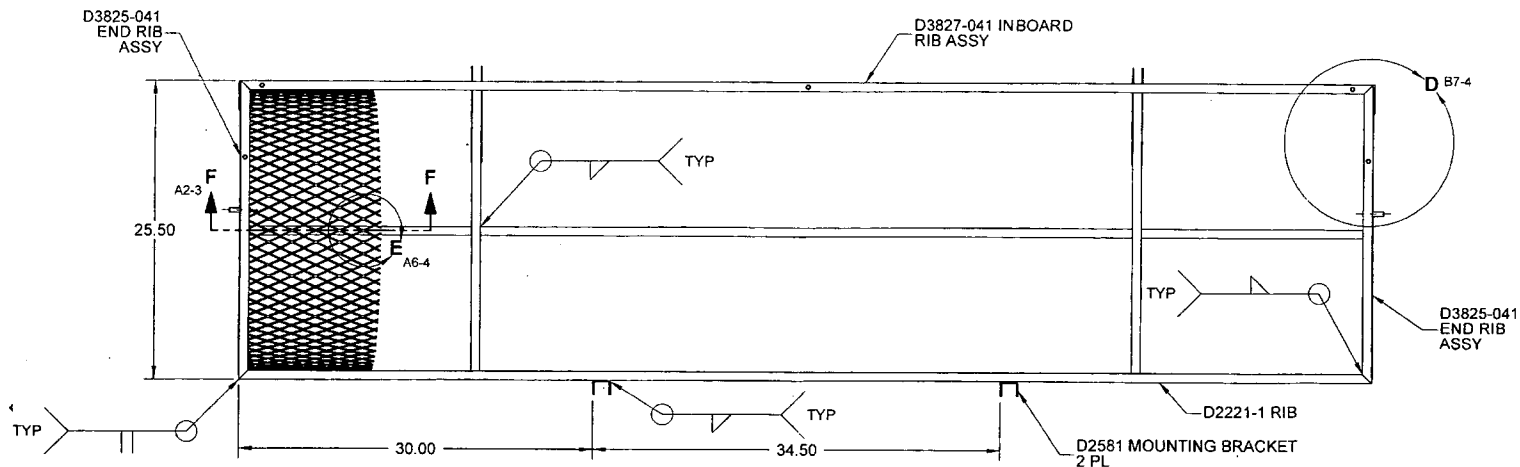
NO. 83907 MCLJ
12/04/27

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|------------------------------|
| 1 | X | D2221 | BASKET BASE ASSEMBLY (AS350) |
| 2 | 1 | D2221-1 | RIB |
| 3 | 2 | D2221-5 | RIB |
| 4 | 1 | D2221-7 | RIB |
| 5 | 2 | D2232-3 | BASKET HINGE |
| 6 | 2 | D2235-1 | RIB |
| 7 | 2 | D2581 | MOUNTING BRACKET |
| 8 | 2 | D3442-1 | SHIM |
| 9 | 2 | D3825-041 | RIB ASSY (BASKET END) |
| 10 | 2 | D3826-041 | RIB/GUSSET ASSY |
| 11 | 1 | D3827-041 | RIB ASSY (INBOARD) |
| 12 | 2 | D3833-1 | MESH, BASE END FACE |
| 13 | 1 | D3832-1 | MESH (BASE) |

RELEASED
08/11/18

| | | | |
|------------|---|---|--------------|
| H | REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM. | MB | 08.09.18 |
| G | MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL. TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT | AJS | 08.06.16 |
| F | ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET | PH | 05.06.07 |
| E | CHANGE HINGE | CP | 01.04.19 |
| D | CHANGE LATCH | BW | 96.06.21 |
| C | SEPARATE BASKET AND LID | KH | 95.11.21 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | BW | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | BW | | |
| CHECKED | BW | DRAWING NO. | REV. H |
| MFG. APPR. | BW | D2221 | SHEET 1 OF 5 |
| APPROVED | BW | TITLE | SCALE |
| DE APPR. | BW | BASKET BASE ASSEMBLY (350) | NTS |
| DATE | 08.09.18 | <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

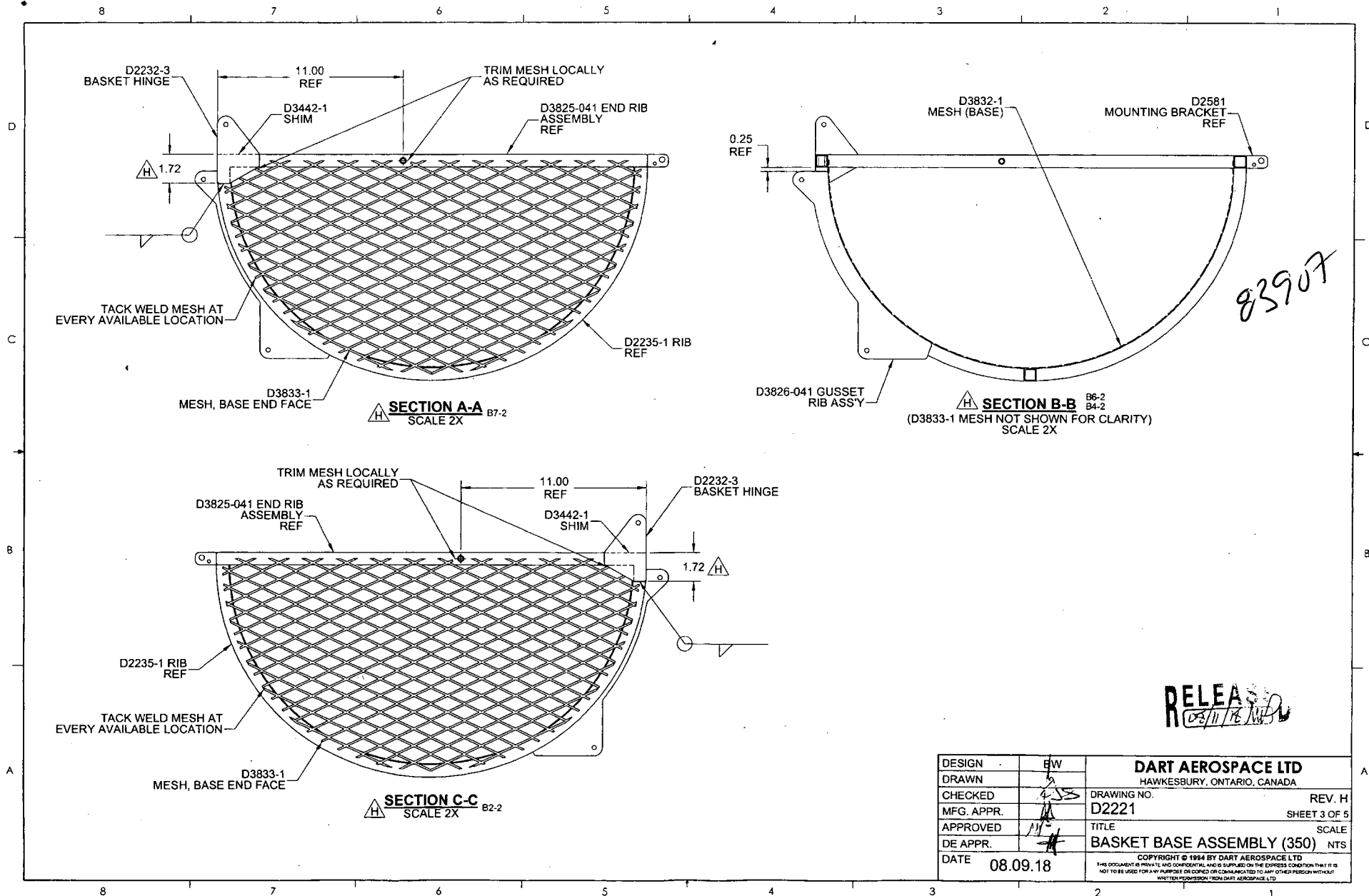
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: 42.00 lbs APPROX
 - 9) MASK ALL HOLES PRIOR TO POWDER COATING



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 NED

| | | | |
|--|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. H |
| MFG. APPR. | | D2221 | SHEET 2 OF 5 |
| APPROVED | | TITLE | SCALE |
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| | | | |
|------------|----------|--|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | 435 | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | 11 | DRAWING NO. D2221 | REV. H |
| MFG. APPR. | | | SHEET 3 OF 5 |
| APPROVED | | TITLE | SCALE |
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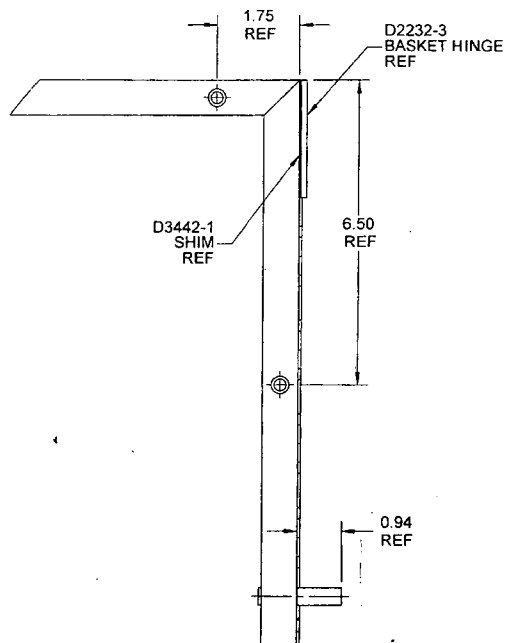
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D

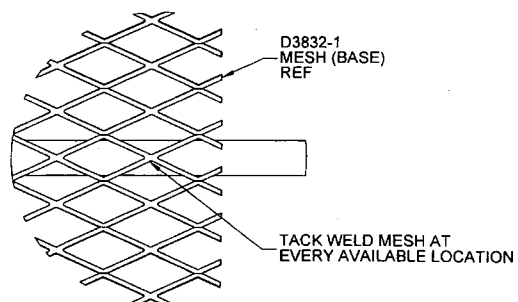
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B

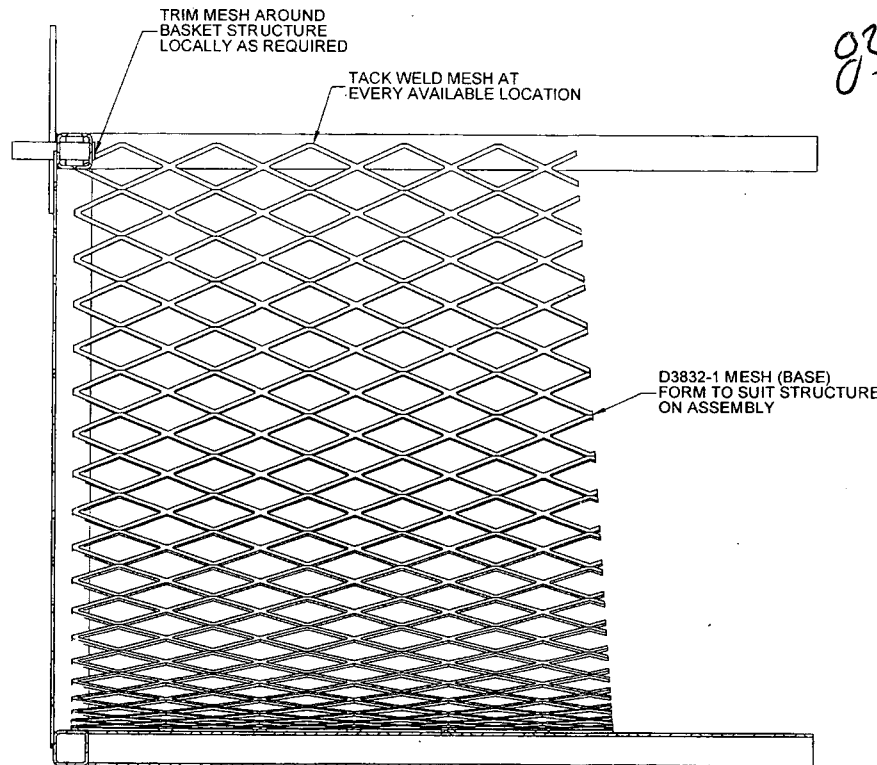
A



DETAIL D
SCALE 4X D2-2



DETAIL E
SCALE 4X C6-2



SECTION F-F
SCALE 4X D7-2

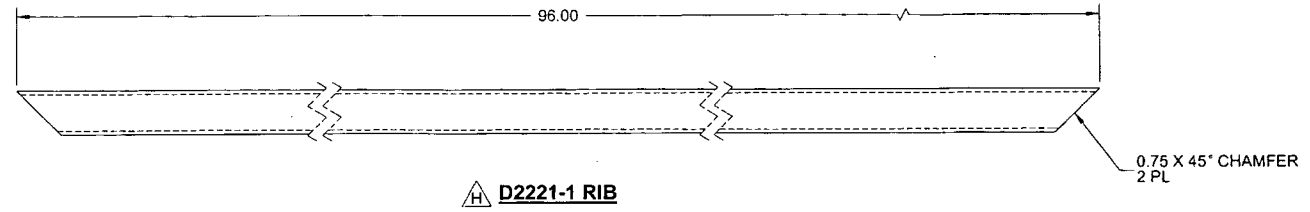
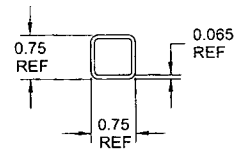
83907

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02/11/18

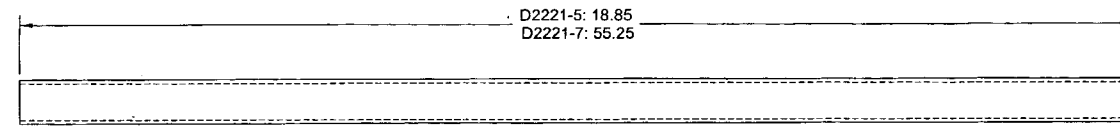
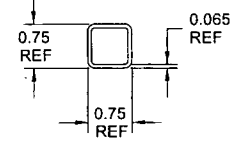
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|--|--------------------|-----------------------------|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. | REV. H |
| MFG. APPR. | <i>[Signature]</i> | D2221 | SHEET 4 OF 5 |
| DE APPR. | <i>[Signature]</i> | TITLE | SCALE |
| DATE | 08.09.18 | BASKET BASE ASSEMBLY (350) | NTS |
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8 7 6 5 4 3 2 1

83907



D2221-1 RIB



D2221-5/-7 RIB

RELEASED
08/11/18

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

| | | | |
|------------|-----------------|---|--------------|
| DESIGN | BW | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. D2221 | REV. H |
| MFG. APPR. | | | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
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